

Date:
User:Monday, 9/17/2007 1:49:10 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 34692		
Estimate Number	: 10311		
P.O. Number	: N/A	Part Number	: D2620
This Issue	: 9/17/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2620 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33880	Drawing Revision	: B
	Type : LANDING GEAR	Material	: N/A
Written By	:	Due Date	: 9/24/2007
Checked & Approved By	: <u>07.09.17</u>	Qty:	30 Um: Each
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty Part Number

1 D2600-1

Description

Extrusion Round 3"206

Batch

30249

SR

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

EL/SR / AWM
07/09/18

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-9-18

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP 7-9-18

(30)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

DP 07/09/18

Job Completion



CL 07/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2620 PAR #: N/A Fault Category: Prod/Landing Gear NCR: Yes No DQA: D Date: 07/09/19
 QA: N/C Closed: D Date: 02.09.19

NCR: <u>34692</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07-09-18</u>	<u>1.0</u>	<u>1 Lbe was found with a big dent on the top. VERY visible.</u>	<u>[Signature]</u> <u>02/09/18</u>	<u>scraper des top. Replace B 30249 Qty 1</u>	<u>[Signature]</u> <u>07-09-18</u>	<u>07-09-18</u>	<u>[Signature]</u>	<u>07-09-18</u>

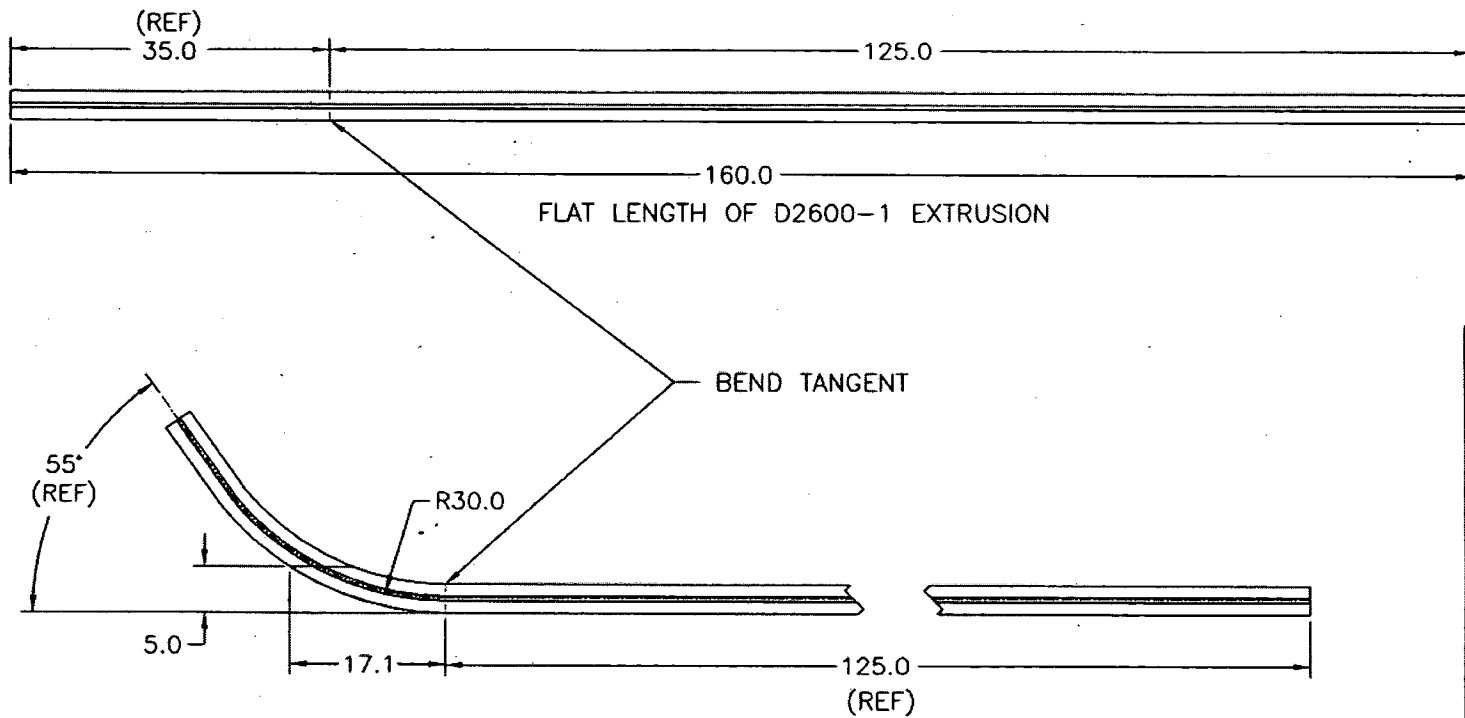
NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

DART

QA COPY ISSUED



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
49.04.15 DS

DESIGN	RT	DRAWN BY	RT	DART AEROSPACE USA, INC.
CHECKED	ME	APPROVED	ME	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	TITLE	206 SKIDTUBE BENDING CONTROL	REV. B
A	97.11.07	NEW ISSUE		SHEET 1 OF 1
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		SCALE 1:20

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WORK ORDER
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